



# Type 304/304L

## UNS S30400 UNS S30403

### General Properties

The basic austenitic stainless steel, a versatile corrosion resistant material for general purpose applications. Type 304/304L is the modern evolution of the original “18-8” austenitic stainless steel. Type 304L is a modification of Type 304 with reduced carbon content of 0.03% maximum for enhanced corrosion resistance after thick section welding.

Type 304/304L is non-magnetic in the annealed condition but may become slightly magnetic as a result of cold working or welding.

### Dual certification

It is common for 304L to be dual certified as 304 and 304L when the material meets the lower carbon limit of Type 304L and the slightly higher strengths of Type 304. The producer of the steel must certify the material as Type 304 if it is to be used as Type 304 instead of Type 304L.

### Specifications

Type 304/304L can be supplied to meet AMS, ASTM, ASME, QQS, and MIL-S specifications.

### Design Features

- Good corrosion resistance
- High ductility and formability
- Excellent impact toughness even at cryogenic temperatures
- Good workability and weldability
- Good machinability

### Applications

- General-purpose applications and environments
- Corrosion resistant storage tanks
- Architectural and structural members
- Water treatment equipment
- Food processing equipment

Chemical Composition (wt%)

Table 1

	C	Mn	Cr	Ni	Mo	N	Other
Typical	0.02	1.4	17.2	9.1	0.4	0.01	
UNS S30400	≤0.08	≤2.00	18.00-20.00	8.00-10.50	...	≤0.10	
UNS S30403	≤0.03	≤2.00	18.00-20.00	8.00-11.00	...	≤0.10	

Corrosion resistance

Type 304/304L is a versatile, general purpose stainless steel with good corrosion resistance to potable water, atmospheric corrosion, many organic and inorganic chemicals, and to foods and beverages.

Heat treatment

Annealing

Type 304/304L should be heated to 1900°F minimum and water quenched or rapidly cooled by other means. Type 304/304L cannot be hardened by heat treatment.

Workability

Cold Working

Type 304/304L is readily formed and fabricated through a full range of cold working operations. It can be used in heading, drawing, bending, and up-setting. Any cold working operations will increase the strength and hardness of the material, and may leave it slightly magnetic.

Hot Working

Type 304/304L can be forged in the 1700-2200°F range. For maximum corrosion resistance, forgings should be annealed at 1900°F minimum and water quenched or rapidly cooled by other means after hot working operations.

Mechanical Properties per ASTM A240 Table 2

	Typical	304	304L
Yield Strength R <sub>p0.2</sub> (KSI)	41	30 min	25 min
Tensile Strength R <sub>m</sub> (KSI)	84	75 min	70 min
Elongation (%)	55	40 min	45 min
Hardness (Rockwell B)	80	92 max	92 max

Physical Properties Table 3

	Typical
Density (lb/in <sup>3</sup> )	0.286
Modulus of Elasticity (psi)	29.0x10 <sup>6</sup>
Coefficient of Thermal Expansion 68-212°F [μin/(in*°F)]	8.9
Thermal Conductivity [BTU/(hr*°F)]	8.7
Thermal Capacity [BTU/(lbm*°F)]	0.12
Electrical Resistivity (μΩ*in)	28.7

Corrosion performance of stainless steels

Table 4 compares the performance of Type 304 with other stainless steels in a variety of common corrosive environments. The table shows the lowest temperature at which the corrosion rate exceeds 5 mpy. All testing was done in accordance with the requirements of the Materials Technology Institute of the Chemical Process Industries (MTI).

Welding

Type 304/304L is readily welded by a full range of conventional welding procedures (except oxyacetylene). AWS E308L/ER308L filler metals should be used with Type 304/304L steel. After welding thick section Type 304, it may be necessary to fully anneal to restore the corrosion resistance lost by sensitization to intergranular corrosion, when chromium carbides were precipitated in the grain boundaries of the weld heat-affected zone. The use of Type 304L should be considered for thick section welding applications, as this low carbon version has enhanced resistance to intergranular carbide precipitation and intergranular corrosion.

Machinability

Type 304/304L is a tough austenitic stainless steel subject to work hardening during deformation and, unless modified for improved machining response, is resistant to chip breaking. The best machining results are achieved with slower speeds, heavier feeds, excellent lubrication, sharp tooling, and powerful, rigid equipment.

## Lowest Temperature (°F) at Which the Corrosion Rate Exceeds 5 mpy

Corrosion Environment	654 SMO®	254 SMO®	904L	Type 316L (2.7 Mo)	Type 304	2507	2205 Code Plus Two®	2304
0.2% Hydrochloric Acid	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling
1% Hydrochloric Acid	203	158	122	86	86p	>Boiling	185	131
10% Sulfuric Acid	158	140	140	122	—	167	140	149
60% Sulfuric Acid	104	104	185	<54	—	<57	<59	<<55
96% Sulfuric Acid	86	68	95	113	—	86	77	59
85% Phosphoric Acid	194	230	248	203	176	203	194	203
10% Nitric Acid	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling	>Boiling
65% Nitric Acid	221	212	212	212	212	230	221	203
80% Acetic Acid	>Boiling	>Boiling	>Boiling	>Boiling	212p	>Boiling	>Boiling	>Boiling
50% Formic Acid	158	212	212p	104	≤50	194	194	59
50% Sodium Hydroxide	275	239	Boiling	194	185	230	194	203
83% Phosphoric Acid + 2% Hydrofluoric Acid	185	194	248	149	113	140	122	95
60% Nitric Acid + 2% Hydrochloric Acid	>140	140	>140	>140	>140	>140	>140	>140
50% Acetic Acid + 50% Acetic Anhydride	>Boiling	>Boiling	>Boiling	248	>Boiling	230	212	194
1% Hydrochloric Acid + 0.3% Ferric Chloride	>Boiling, p	203ps	140ps	77p	68p	203ps	113ps	68p
10% Sulfuric Acid + 2000ppm Cl <sup>-</sup> + N <sub>2</sub>	149	104	131	77	—	122	95	<55
10% Sulfuric Acid + 2000ppm Cl <sup>-</sup> + SO <sub>2</sub>	167	140	122	<<59p	—	104	<59	<<50
WPA1, High Cl <sup>-</sup> Content	203	176	122	≤50	<<50	203	113	86
WPA2, High F <sup>-</sup> Content	176	140	95	≤50	<<50	167	140	95

ps = pitting can occur  
ps = pitting/crevice corrosion can occur

WPA	P <sub>2</sub> O <sub>5</sub>	Cl <sup>-</sup>	F <sup>-</sup>	H <sub>2</sub> SO <sub>4</sub>	Fe <sub>2</sub> O <sub>3</sub>	Al <sub>2</sub> O <sub>3</sub>	SiO <sub>2</sub>	CaO	MgO
1	54	0.20	0.50	4.0	0.30	0.20	0.10	0.20	0.70
2	54	0.02	2.0	4.0	0.30	0.20	0.10	0.20	0.70

### **Technical support**

New Castle assists users and fabricators in the selection, qualification, installation, operation, and maintenance of 304/304L stainless steel. Technical personnel can draw on years of field experience with 304/304L to help you make the technically and economically correct materials decision. New Castle is prepared to discuss individual applications and to provide data and experience as a basis for selection and application of 304/304L.

New Castle works closely with its distributors to ensure timely availability of 304/304L in the sizes and quantities required by the end user. For assistance with technical questions and to obtain top quality 304/304L call New Castle at 1-800-349-0023.



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## Stainless Plate, LLC